Jerev 55277

Work Order ID 53299



Page 1

Insp.

Stamp

October 29, 2009 2:17:00 PM Item ID: PB67-43001-193 Accept Setup Start **Revision ID:** C Stop D-Pad Base Item Name: **Start Date:** 10/30/2009 Start Qty: 24.00 **Cust Item ID: Required Date:** 11/16/2009 Req'd Qty: 24.00 **Customer:** Reference: Start Run Date: 09-10-29 Process Plan: WF Approvals: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Reject Set Up/ Accept Reject Draw Draw Plan **Work Center ID** Description **Run Hours** Number Rev. Code Qty Qty Number **Draw Nbr Revision Nbr** B67-43001 C 100 0.00 FLOW WATER JET B 10-1-5 Wateriet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg PB67-43001-193 Dwg Rev: 861.1200 Prog Rev: 2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

B10-1-5

Quality Control

Dart Aerospace L	_td
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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Ye	s No D	QA:	Date: _	
	Re	esolution:	Dispositio	n:	_ QA: N/C	Closed: _		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NO	R)			
DATE	STEP	Description of NC Section A	Initial Action Description				ification ection C	Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Da	te		Office Ling	QO IIIspector

C

Required Date: 11/16/2009



Page 2

Item ID:

October 29, 2009 2:17:00 PM

PB67-43001-193

Accept

Setup Start

Stop



Revision ID:

Item Name:

D-Pad Base

Start Date:

10/30/2009

Start Qty: 24.00

Req'd Qty: 24.00



Date:_____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling: SPC (Y/N):

0.00

2) Scoloclos

Date: Date:

Stop

Run

Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours** Draw Number Draw Plan Rev. Code

Accept Qty Qty

Reject

Start

Reject Insp. Number Stamp

courlie

130

Small Fab

Small Fab

Small Fab

Memo

1- c'sink as per dwg.

2- Install nutplate with rivet.

0.00

0.00

140

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

	Dart	Aero	ospace	Ltd
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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	Part No: PAR #:								
	Re	esolution:	Dispositio	n:	_ QA: N/C C	losed:		Date: _	
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DATE	STEP	Description of NC		on B	Verific	cation	Approval	Approval	
DAIL	0,2,	Section A	Initial Chief Eng	Action Description Chief Eng -	Sign Date		on C	Chief Eng	QC Inspector
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Work Order ID 53299

October 29, 2009 2:17:00 PM

Required Date: 11/16/2009



Page 3

Item ID:

PB67-43001-193

Accept

Setup Start



Revision ID: \mathbf{C}

Item Name: D-Pad Base

10/30/2009

Start Qty: 24.00

Req'd Qty: 24.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Start Date:

Approvals:

Process Plan: QC: ____

Date: _____

Date: Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date: Date: Run

Start

Stop

Stop

Sequence ID/

Work Center ID

150

Packaging

Operation Description

Identify as per dwg & Stock Location: 4460

0.00

0.00

0.00

Draw Rev.

Plan Code Accept Reject Qty Qty

Reject Number

Insp. Stamp

Packaging

160

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

Memo

0.00

10/01/12/1 MF 10-1-12

Dart	Aeros	pace	Ltd
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W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No: PAR #:			Fault Cate	egory:	NC	R: Yes	No DQ	A:	Date:				
		esolution:											
NCR:		\	WORK ORD	ER NON-CON	FORMANC	E (NCF	l)			₹ ₩ 4 kr as tombe			
DATE	STEP	Description of NC	Description of NC Corre				Verific	cation	Approval	Approval			
	0.2.	Section A	Initial Action Descri Chief Eng Chief Eng		cription ing	Sign & Date			Chief Eng	QC Inspector			
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Picklist Print

October 29, 2009 2:16:59 PM

Work Order ID: 53299

PB67-43001-193RevB1

Parent Item Name: D-Pad Base

Parent Item:



Start Date: 10/30/2009

Required Date: 11/16/2009

Page 1

Comments:								5	Start Qty: 24.00)	Required Qty:	24.00
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
CCR264SS3-3	1 HOM 104 HILL HALLON	Purchased	No			130	Each	65.0000	96.0000	Sio	Poji fii	
				<u>Wareho</u> <u>Loc</u> Main W	ation	<u>Loc</u>	<u>Oty</u>	Loc Code		MOIS	3068 (152X)	
				ST			65				M113	C39/6
					111548 111827 112314		38 1 26				71110	
M6061T6S.125	1)	Purchased	No			100	sf	104.7952	0.2779	٠٦	IR 10	-1-5
				Wareho Loc	use ation	<u>Loc</u>	Oty	Loc Code				,
				Main W		104	7050				•	
				MA		104	.7952			 	•	
					110062 111642	1	1.85 9.592		_			
					112476	•	32					
					112567		.3532		1	12567		
MS21075L3		Purchased	No			130	Each	175.0000	48.0000	95 10	/o1/11_	•
лафии				<u>Wareho</u> <u>Loc</u>	ouse ation	Loc	Oty	Loc Code		/		
				Main W	arehouse							
				ST			175					
					112991		175		_	104		

M 113539

Dart Aeros	pace Ltd
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W/O:	•		WC	RK ORDER CHANGE	ES					
DATE	STEP	PR	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR:	Yes N	lo DQ	A:	Date: _	
		esolution:								
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR)			•	
DATE	STEP	Description of NC Corrective Action			n B		Verific	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector
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DART AEROSPACE LTD	1//	Work Order:	53799
Description: D-Pad Base	60/20/	Part Number:	B67-43001-193
Inspection Dwg: B67-43001, Pg25	Rev: 81		Page 1 of 1

•	FIRS	T ARTICLE I	NSPECTI	ON CHE	CKLIST		
	X	First Art	icle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	iments
Ø0.1943	/+0.005/-0.001						
1938	1/-0-030						
70.75	+/-0.030						
~0.50	+/ 0.030						
1.00	+/-0.030	110.1	×				
1.48	+/-0.03 0						
Ø0.098 ✓	+0.004/-0.001	୍ଷ୍ୟ	*				
J.194	+.00S	1195	X				
1,500	+/-010.	502,	>				
1.560	+/-0/0	1.569	19				
.750	+/-005	751	×				
./38	+/-030	123	≯				
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Measured by:	B	Audited by:			Prototype Ap	proval:	N/A
Date:	10-1-5	Date	- , /	2		Date:	N/A
Rev Date	Change			· . 	Revis	sed by	Approved
A 08.09.12	New Issue				KJ/DI) of	X

-	Rev	Date	Change	Revised by	Approved	
	Α	08.09.12	New Issue	KJ/DD OX	<i>X</i>	
1					•	

Ø0.098 THRU R1.56 -- 0.500 --- 4 PL 0.750 1.480 1.56 0.375 Ø0.194 THRU 0.250 2 PL 0.13 REF 0.500 - 1.00

B67-43001-193F D-PAD BASE

53299 Ø0.180 X 100° 4 PL

> B67-43001-193 D-PAD BASE (MAKE FROM B67-43001-193)

D

REDRAWN PREMIER AVIATION DRAWING IAW DART OSI 018 AND QSI 043. FOR PREVIOUS REVISONS, REFER TO PAGE 25 OF PREMIER AVIATION DRAWING No. 867-43001. REASON: SEE PARK99-011. 09.03.03 REV. DESCRIPTION DATE DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. C B67-43001-193 MFG. APPR. SHEET 1 OF 1 APPROVED TITLE SCALE DE APPR. **D-PAD BASE** NTS COPYRIGHT @ 1995 BY DART AEROSPACE LTD
THIS DOCUMENT IS IMPACTE AND CONFIDENTIAL AND IS BUPPLED ON THE INPRESS CONDITION TO BE USED FOR ANY PARPOSE OR COPIED OR COMMANCIATED TO ANY OTHER POSICIANS. DATE 09.03.03

NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027 REF. DART SPEC. M6061T6S.125

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A 7) WEIGHT: 0.02 lbs

3

2

D

С

Dart Aerospace Ltd	Da	ırt	Aer	osp	oace	Ltd
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W/O:	•		WO	DV ODDED CHANC	FC					
DATE	STEP	WORK ORDER CHANGES PROCEDURE CHANGE					Date	Qty	Approval Chief Eng /	Approva QC Inspector
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								<u></u>		
Part No: PAR #:		PAR #:	Fault Categ	ory:	_ NCR: Y	es No	o DQ	\ :	_ Date: _	
Resolution:			Disposition: (A: N/C Closed:			Date:	
NCR:		. ,	WORK ORDE	R NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC	Corrective Action Section B			Verif		ication	Approval	Approval
DAIL	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sig D	ın & ate	Secti	on C	Chief Eng	QC Inspector
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